

CLAIMS

1. A method of producing a bushing for a roller chain having a pair of end portions at opposite ends thereof and tapered internal circumferential surfaces at both said end portions, the method comprising the steps of:

press-forming a solid cylindrical blank of a required length to form a hollow cylindrical blank having required inner and outer diameters, and having end portions;

thereafter, by using a finishing die having an internal circumferential surface with a diameter the same as or slightly smaller than the outer diameter of said hollow cylindrical blank, and a pair of punches having small diameter end portions which have the same diameters as the inner diameter of said hollow cylindrical blank, large diameter portions, which have diameters the same as the diameter of the internal circumferential surface of said die, and tapered portions provided between said large diameter portions and said small diameter end portions respectively, press-fitting said hollow cylindrical blank into the die with one punch of said pair of punches and, at the same time, press-fitting the small diameter end portions and tapered portions of the pair of punches into both end portions of said hollow cylindrical blank while restraining both end surfaces of the press-fitted hollow cylindrical blank with punch side members; whereby the outer circumferential surface of the cylindrical blank is finish-molded in the required

diameter, and, at the same time, tapered surfaces are formed on inner circumferential surfaces of both end portions of the cylindrical blank.

2. A method of producing a bushing according to claim 1, in which, in a later step, an internal circumferential surface of said hollow cylindrical blank other than the tapered internal circumferential surfaces at both end portions thereof is subjected to sizing.